

# Work Order ID 60588

Thursday, July 15, 2010 10:18:26 AM



Page 1

Item ID: D205-778-011

Accept



Setup Start



Revision ID:

Item Name: Comfort Seat, LH/RH

Stop



Start Date: 7/15/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*H*

Date: 10-7-15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

DSI 9508

A

IIN D205-778

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D205-778-011

CHG 002

4/6/2013

Sulor 1/5

*H* for BG 11-3-15

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

*P* 4/3/11 *U*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval <sup>1</sup> QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 60588**

Thursday, July 15, 2010 10:18:26 AM

Page 2

Item ID: D205-778-011

Accept

Revision ID:

Item Name: Comfort Seat, LH/RH

Start Date: 7/15/2010 Start Qty: 1.00

Required Date: 7/22/2010 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

Sulor/45

②

130



Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D205-778-101

Location: \_\_\_\_\_  
PPP Rev: C

0.00

0.00

14/3/86 ①

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/3/16 ②

MF

11-03-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, July 15, 2010 10:18:30 AM

Page 1

Work Order ID: 60588

Parent Item: D205-778-011

Parent Item Name: Comfort Seat, LH/RH

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-10-20 New Issue DD verified by:EC  
per DSI 9508 DD 10.03-24 verified by:EC IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
S AN960JD6L Washer		Purchased	No			110	Each	1,056.000	16	16			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST347				1056					
					5519			1056					
S BSP-42 Rivet		Purchased	No			110	Each	160.0000	8	8			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST				160					
					114598			160					
S D3752-1 Seat Frame		Manufactured	No			110	Each	1.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST252A				1					
					58352			1					
S D3755-041 Seat Cushion		Manufactured	No			110	Each	1.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST252A				1					
					58260			1					

58260

67226 Rev C 6/13/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, July 15, 2010 10:18:30 AM

Page 2

Work Order ID: 60588

Parent Item: D205-778-011

Parent Item Name: Comfort Seat, LH/RH

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

D3756-041

Manufactured No

110

Each

5.0000



Cushion



Location

Loc Qty

Loc Code

ST252A

5

55981

2

57908

2

58261

1

D3758-041

Manufactured No

110

Each

17.0000



Clamp



Location

Loc Qty

Loc Code

ST086

17

58262

17

D3777-041

Manufactured No

110

Each

14.0000



Clamp



Location

Loc Qty

Loc Code

ST087

14

46659

14

D3800-3-200 -060 x4 per ki'

Manufactured No

110

f

252.4747



Hook and Loop Strip (2" Hard)



Location

Loc Qty

Loc Code

ST089

252.4747

43367

106.6847

56393

70.79

60044

75

1 - Cut to length as per dwg

measured  
5'0" x 4' per kit

60" x 4' per kit

Thursday, July 15, 2010 10:18:30 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Thursday, July 15, 2010 10:18:30 AM

Work Order ID: 60588

Parent Item: D205-778-011

Parent Item Name: Comfort Seat, LH/RH

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

AN525-10R8

Purchased

No

110

Each

100.0000



Screw



114999

Location

Loc Qty

Loc Code

ST325

100

111274

3

114494

97

AN970-3

Purchased

No

110

Each

100.0000



Washers



116158

Location

Loc Qty

Loc Code

ST349

100

115158

100

AN960JD10

NAS1149D0363J

Purchased

No

110

Each

0.0000



Washer



116391

MS21042L3

Purchased

No

100

Each

2,684.000



Nut



116391

Location

Loc Qty

Loc Code

ST300

2684

112385

4

114523

204

114718

476

114784

2000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

#### 4.0 WEIGHT AND BALANCE

The following is the net weight increase associated with the modification kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-778-011	13.0 lb	±22.0 in	±286 in-lb	47.0 in	611 in-lb
Comfort Seat Kit, LH / RH	5.9 kg	±0.56 m	±3.3 m-kg	1.19 m	7.0 m-kg

#### 5.0 PARTS LIST

Qty -011	Part Number	Description
X	D205-778-011	COMFORT SEAT KIT (FITS LH & RH)
1	D3752-1	SEAT FRAME
1	D3755-041	CUSHION
1	D3756-041	CUSHION
2	D3758-041	CLAMP ASSEMBLY
*2	D3758-1	CLAMP
*2	D2182B028	RUBBER CUSHION
2	D3777-041	CLAMP ASSEMBLY
*2	D3777-1	CLAMP
*2	D2182B013	RUBBER CUSHION
4	D3800-3-200-060	HOOK STRIP
8	AN525-10R8	SCREW
8	AN970-3	WASHER
8	AN960JD10	WASHER
8	MS21042L3	NUT (OR MS21042-3)

\* REFERENCE ONLY. PARTS ARE INCLUDED IN ASSEMBLY ABOVE.

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-778 **REFERENCE ONLY**  
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-778 REV. 1  
REF TCCA STC: SH08-37  
REF FAA STC: SR02704NY  
REF EASA STC: EASA.IM.R.S.01518

## PURPOSE:

To provide instructions to allow the hook strip (ie. velcro) on the D3752-1 Seat Frame to be fastened with rivets.

## CHANGE:

D205-778-011 Comfort Seat Kits at CHG 002 have rivets and washers that may be installed to fully secure the D3800-3-200-060 Hook Strip to the D3752-1 Seat Frame. The parts list of Installation Instructions IIN-D205-778 and Instructions for Continued Airworthiness ICA-D205-778 is amended as shown below. Installation of the rivets is optional.

## PARTS LIST

QTY -011	Part Number	Description
X	D205-778-011	Comfort Seat Kit
8	BSP-42 L	Rivet (Add)
16	NAS1149DN616J	Washer (or AN960JD6L) (Add)

## INSTALLATION INSTRUCTIONS

Install the BSP-42 rivets as detailed below, see Figure 1 of this service instruction as reference:

- 1) Ensure location of D3800-3-200-060 Hook Strip lines up with loop strip on seat cushions.
- 2) Drill D3752-1 Seat Frame using 9/64" (Ø0.141) drill in appropriate locations: ensure rivet location will not interfere (contact) with the OEM metal seat frame. Deburr hole.
- 3) Install each BSP-42 rivet with qty(2) NAS1149DN616J washers (one on either side of the plastic seat frame). It is acceptable to substitute longer/shorter BSP rivets or thicker NAS1149DN632J washers to ensure proper fit.

## UPGRADE KIT

For D205-778-011 Comfort Seat Kits at CHG 001, the DSI-9508-011 Rivet Kit is available from Dart:

QTY -011	Part Number	Description
X	DSI-9508-011	Rivet Kit
8	BSP-42	Rivet
16	NAS1149DN616J	Washer (or AN960JD6L)

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 10.03.02  
CERT. NO.: SH08-37  
ISSUE NO.: 1

A	NEW ISSUE	CP	10.03.02
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>qp</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>qp</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9508	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIVET KIT	NTS
DATE	10.03.02	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Part Number D205-778-011Page 1 of 1

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